



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Del April 10

D4095-043
Job Sheet 175237



Part No: D4095-043

Job Qty: 8 ea

Part Name: Wearplate Aft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/29/18

Job Tracking No:

Due Date: 4/10/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D SHEETS 1,2,5,6,9 IPP Rev:A new issue DD 10.04.26 verified by:EC IPP REV:B 15.10.29
AUTOMATED WELDING DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	4/9/18	4/9/18	0.00	0.00	Start Up Waterjet		<i>38 8/24/02</i>
100	Waterjet	8 pcs	4/9/18	4/9/18	0.00	2.88	Waterjet1		<i>38 8/24/02</i>
110	QC	8 pcs	4/9/18	4/9/18	0.00	0.00	QC2 Waterjet-3		<i>38 8/24/02</i>
120	QC	8 pcs	4/9/18	4/9/18	0.00	0.00	QC8-4		<i>38</i>
130	Brake NC	8 pcs	4/9/18	4/9/18	0.00	1.78	Brake NC 1		<i>38 9-86</i>
140	QC	8 pcs	4/9/18	4/9/18	0.00	0.00	QC5		<i>38</i>
150	Autoweld 1	8 pcs	4/9/18	4/9/18	0.00	8.00	Automated welding		<i>38 DAS</i>
160	QC	8 pcs	4/9/18	4/9/18	0.00	0.00	QC10		<i>38 9-86</i>
170	QC	8 pcs	4/9/18	4/9/18	0.00	0.00	QC5		<i>38 9-86</i>
180	HandFinish	8 pcs	4/10/18	4/10/18	0.00	0.38	HandFinish4		<i>38</i>
190	QC	8 pcs	4/10/18	4/10/18	0.00	0.00	QC3		<i>38</i>
200	Packaging	8 pcs	4/10/18	4/10/18	0.00	0.00	Packaging3-2		<i>38</i>
210	QC21-SA	8 Ea	4/10/18	4/10/18	0.00	0.00	QC21		<i>38</i>

Part Op 100 - 1-Cut as per Dwg (D4095-3)

Descriptions: 130 - 1- bend section C-C first

140 - Ensure joggle as per dwg D4095

150 - ***SEE NOTE 10 FOR SURFACE BUILDUP***

180 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG 138842

200 - LOCATION : FG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	18.2000 sf (2.275 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	18	288	0

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																														
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DART AEROSPACE Part: D4095-043 Job No: 175237 Serial No/Batch: S057533 Revision: _____ Inspector: _____ Date: 04/02/19 Container No: S057533 Dart Aerospace Ltd. 1270 Aberdeen Street Haverhill, ON K4A 1K7 CANADA TEL.: 1 813 632-6200 Email: sales@dartaero.com www.dartaerospace.com																																																																																																
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: left; padding: 5px;">Root Cause</th> </tr> </thead> <tbody> <tr> <td style="width:15%;">Environment</td> <td style="width:5%;">☐</td> <td style="width:15%;">No Re-verification</td> <td style="width:75%;">☐ Pressure/Forced</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> <td>☐ Bending</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Setup</td> <td>☐ Centre Not Concen</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐ Cracks</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐ Crimp/Kink/Ripple/</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐ Cuffs</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐ Crushing</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐ Heat Treat</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐ Wave/Twist in Tube</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐ Marks/Chatter</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐ Contamination</td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐ Countersink</td> </tr> <tr> <td colspan="3"></td> <td>☐ Cut Too Short</td> </tr> <tr> <td colspan="3"></td> <td>☐ Instructions Incomplete/Unclear</td> </tr> <tr> <td colspan="3"></td> <td>☐ Drill Holes</td> </tr> <tr> <td colspan="3"></td> <td>☐ Wrong Stock Pulled</td> </tr> <tr> <td colspan="3"></td> <td>☐ Out of Sequence</td> </tr> <tr> <td colspan="3"></td> <td>☐ Off-set</td> </tr> <tr> <td colspan="3"></td> <td>☐ Mislabeled</td> </tr> <tr> <td colspan="3"></td> <td>☐ Fit/Function</td> </tr> <tr> <td colspan="3"></td> <td>☐ Misaligned/off center</td> </tr> <tr> <td colspan="4" style="text-align: center;"> OTHER : _____ </td> </tr> </tbody> </table>					Root Cause				Environment	☐	No Re-verification	☐ Pressure/Forced	Design	☐	Operator	☐ Bending	Doc/Data	☐	Offset/Setup	☐ Centre Not Concen	Equip/Tooling	☐	Supplier	☐ Cracks	Handling/Pre	☐	Training	☐ Crimp/Kink/Ripple/	Material	☐	Use for Testing	☐ Cuffs	Internal Transport	☐	Poor Information	☐ Crushing	Tribal Knowledge	☐	Rushing	☐ Heat Treat	LOA	☐	Product Improvement	☐ Wave/Twist in Tube	Substation	☐	Process Improvement	☐ Marks/Chatter	Past Expiry Date	☐	Manufacturing Process	☐ Contamination	Misidentified	☐	Past Due	☐ Countersink				☐ Cut Too Short				☐ Instructions Incomplete/Unclear				☐ Drill Holes				☐ Wrong Stock Pulled				☐ Out of Sequence				☐ Off-set				☐ Mislabeled				☐ Fit/Function				☐ Misaligned/off center	OTHER : _____			
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Part Specifications
Specifications could not be found.

Plex 3/29/18 12:32 PM dart.lacelle.linda

QA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
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OTHER : ☐					

175237

INSPECTION SHEET

DAS
38

SC
18/04/18

Date:

DQA: _____ Date: _____



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